Work Order ID 83491

April-18-12 2:45:42 PM

83491

Item ID: D2662-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Saddle, RH In 206

Start Date: 18/04/2012 **Start Qty:** 6.00 *6*

Required Date: 02/05/2012 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLJ **Date:** 12/04/19 **Tooling:** _____ **Date:** _____

QC: _____ _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2662	Rev E								
100		0.00							
100	HAAS CNC VERTICAL MACHINING #1					10	ϕ		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Program part number and batch number. Inspect part number and batch number are programmed MACHINE AS PER FOLIO FB069 & DWG DWG REV: E FOLIO REV: AA								
110		0.00							
110	CONVENTIONAL MILLING MACHINE					10	ϕ		
Mill Conv	**Memo**	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								

JL 12-05-14

D.A 12/05/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D2662-2 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle, RH In 206
Start Date: 18/04/2012 **Start Qty:** 6.00 *6*
Required Date: 02/05/2012 **Req'd Qty:** 6.00 *6*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB	0.00	SL 12-05-14			10	0		
	Memo	0.00							
130 *130* QC Quality Control	QC8- Inspect parts - second check	0.00	BA 12/05/16			10	0		
	Memo	0.00							
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				10			
	Memo	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 83491

April-18-12 2:45:42 PM

83491

Item ID: D2662-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Saddle, RH In 206 **Stop** *NS2*

Start Date: 18/04/2012 **Start Qty:** 6.00 *6*

Required Date: 02/05/2012 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150 Powdercoat						10X	0		12/05/17
Powder Coating	**Memo** START TIME: 7:30 OVEN TEMPERATURE: 320°F FINISH TIME: 8:00	0.00							
W.21134									
160	QC3- Inspect Part Finish	0.00							
160 QC						10	0		12-5-17
Quality Control	**Memo**	0.00							
170	Identify as per dwg & Stock Location: 434	0.00							
170 Packaging						12/5/17		(10)	
Packaging	**Memo**	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 83491

April-18-12 2:45:42 PM

83491

Item ID: D2662-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Saddle, RH In 206 **Stop** *NS2*

Start Date: 18/04/2012 **Start Qty:** 6.00 *6* **Cust Item ID:**

Required Date: 02/05/2012 **Req'd Qty:** 6.00 *6* **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00					12/5/17		
180									
QC	**Memo**	0.00							
Quality Control									

MF 12-05-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

April-18-12 2:45:46 PM

Work Order ID: 83491

83491

Parent Item: D2662-2

D2662-2

Parent Item Name: Saddle, RH In 206

Start Date: 18/04/2012 **Required Date:** 02/05/2012

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	57.0000	1	6			
D6101-001 Saddle Billet									**	JL 12-05-13			

Location	Loc Qty	Loc Code	
MAT040	3		
69677	2		
76836	1		
MAT041	54		
80764	4		
81923	50		

83309

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	83491
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-2
Inspection Dwg: D2662 **Rev:** E **DSK:** **Rev:**			Page 1 of 1

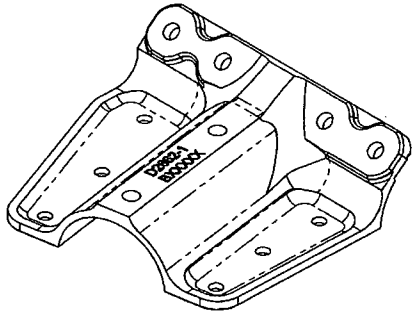
FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**5**
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.119	.120	.119	.119	.119
G	0.210	0.230		.219	.219	.220	.219	.219
H	0.615	0.685		.680	.680	.680	.680	.680
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.322	1.323	1.323	1.322	1.322
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.142	1.137	1.133	1.133	1.132
N	0.100	0.180		.140	.140	.140	.140	.140
O	0.100	0.140		.110	.115	.115	.116	.115
P	0.240	0.260		.245	.248	.251	.250	.250
Q	0.677	0.697		.686	.687	.687	.687	.687
R	0.540	0.560		.550	.551	.550	.550	.550
S	0.912	0.932		.922	.922	.922	.922	.922
T	0.787	0.807		.798	.797	.797	.797	.797
U	5.990	6.010		6.001	6.001	6.001	6.001	6.001
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.498	.499	.500	.495	.500
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		1.001	1.001	1.001	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.501	.501	.501	.500	.499
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.125	.123	.123	.125	.124
AE	0.235	0.240		0.239	0.238	0.238	0.238	0.237
AF	0.510	0.515		0.510	0.510	0.511	0.511	0.510
AG	0.100	0.120		0.115	0.117	0.115	0.117	0.117
AH	1.565	1.585		1.582	1.577	1.573	1.573	1.572
			Accept/Reject					

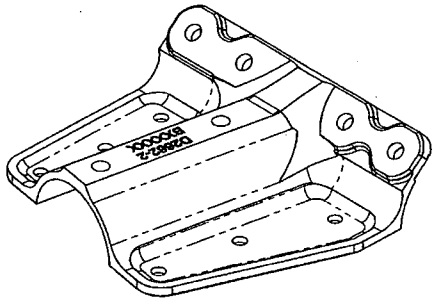
Measured by:	SL	**Date:**	12-05-13
Audited by:	M.a	**Date:**	12/05/16
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83491 MCJ
12/04/B



D2662-1 SADDLE, INSIDE, LH



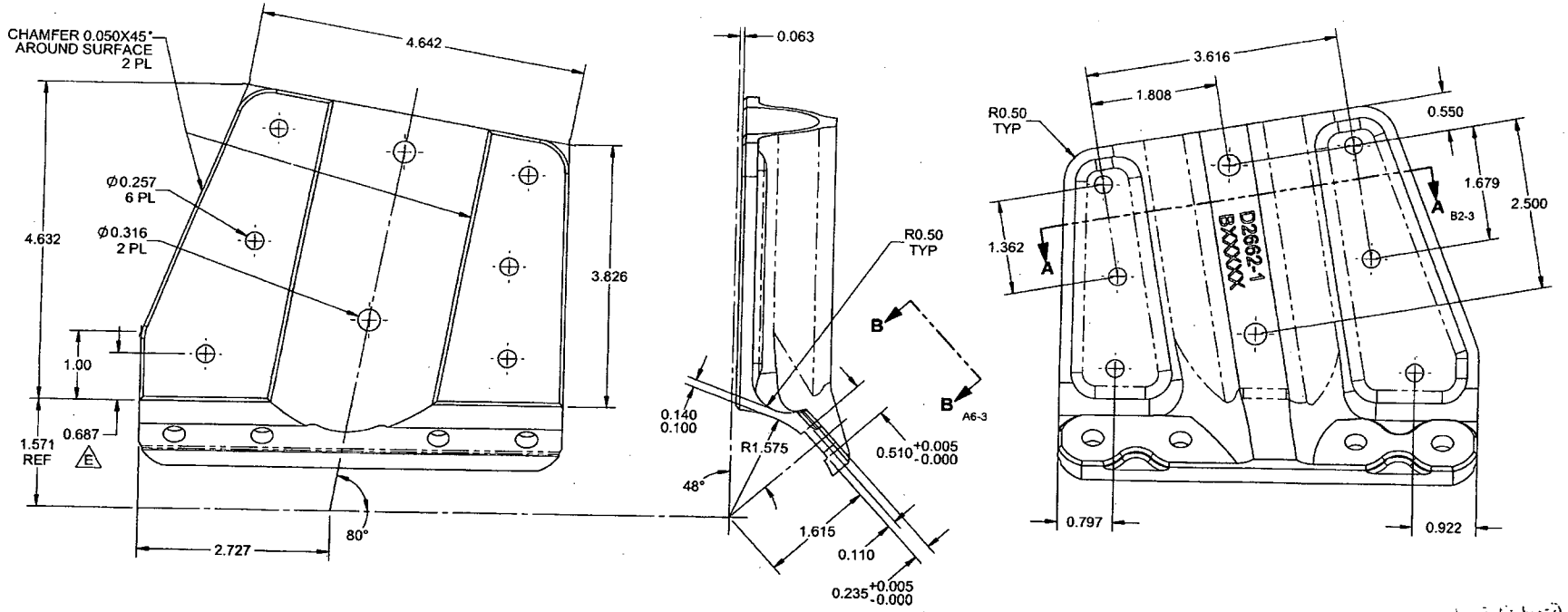
D2662-2 SADDLE, INSIDE, RH

RELEASED
2011-11-16

REV.	DESCRIPTION	BY	DATE
E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP' DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25

DESIGN		DART AEROSPACE USA, INC. KENT, WA	
DRAWN			
CHECKED		DRAWING NO. D2662	REV. E
MFG. APPR.			SHEET 1 OF 5
APPROVED		TITLE SADDLE, INSIDE	SCALE NTS
DE APPR.			
DATE	11.10.31		

83491



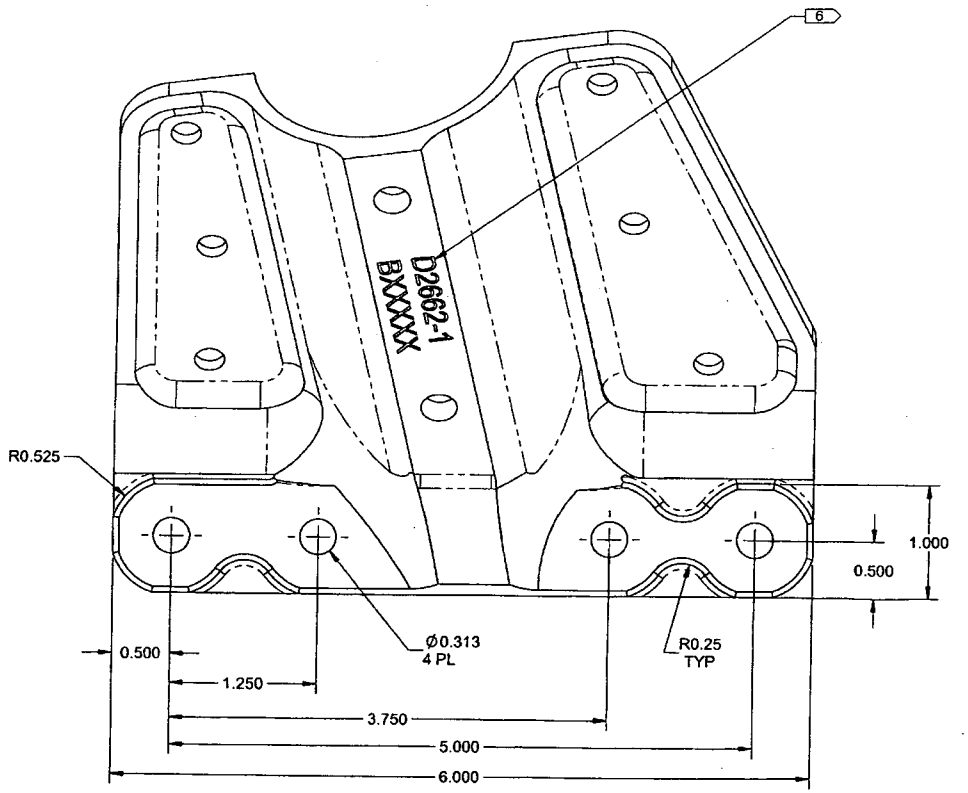
RELEASED
2011-11-16

D2662-1 SADDLE, INSIDE, LH

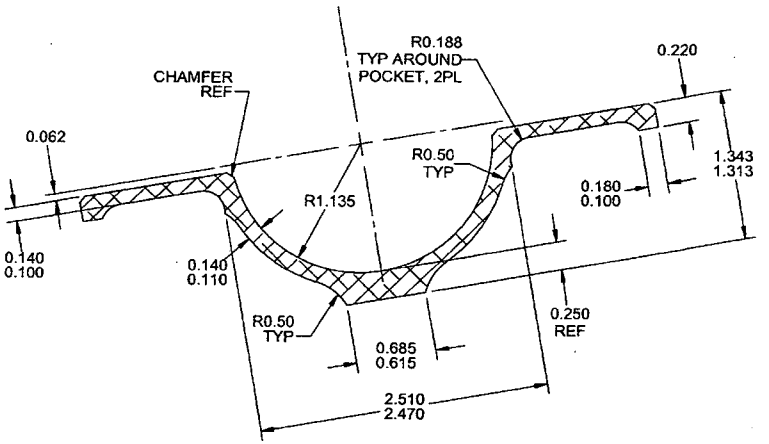
1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO. D2662	REV. E
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE SADDLE, INSIDE	SCALE NTS
DE APPR.			
DATE 11.10.31			

83491



VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED

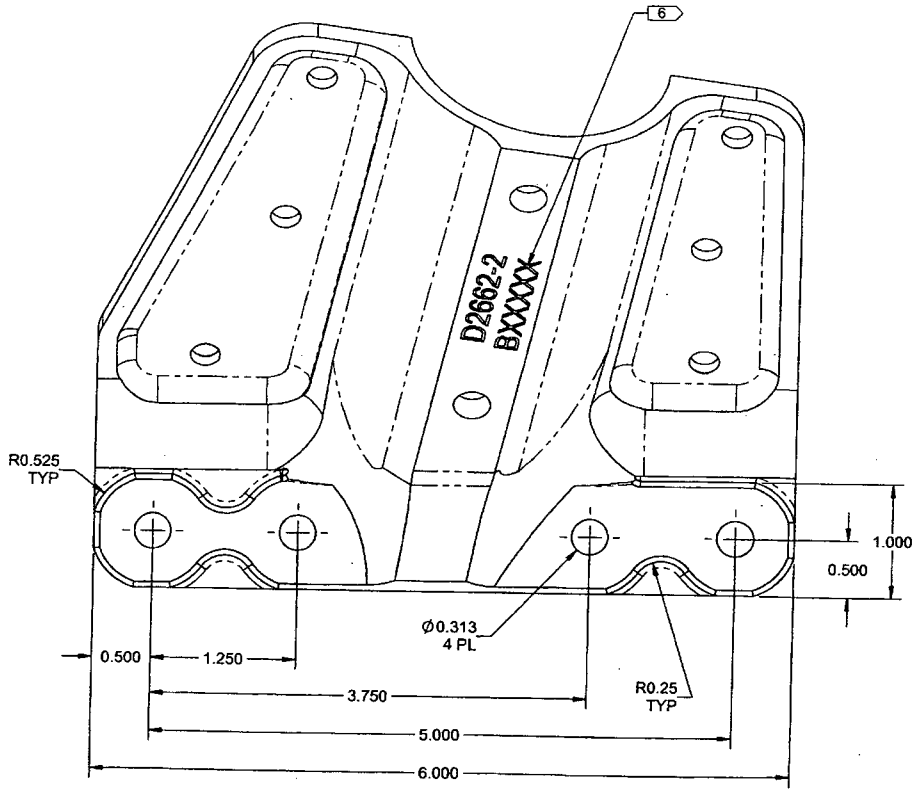


VIEW A-A C1-2
SCALE 1.5X

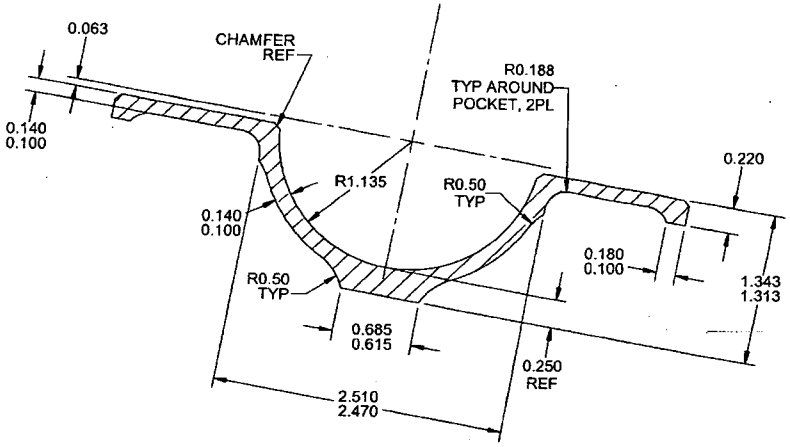
RELEASED
2011-11-16

DESIGN		**DART AEROSPACE USA, INC.** KENT, WA	
DRAWN		DRAWING NO. D2662	REV. E
CHECKED			SHEET 3 OF 5
MFG. APPR.		TITLE SADDLE, INSIDE	SCALE NTS
APPROVED			
DE APPR.			
DATE 11.10.31			

83491



VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



VIEW C-C
SCALE 1.5X C3-4

RELEASED
2011-11-16

DESIGN		**DART AEROSPACE USA, INC.** KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2662 REV. E
MFG. APPR.		SHEET 5 OF 5
APPROVED		TITLE SADDLE, INSIDE SCALE NTS
DE APPR.		
DATE 11.10.31		

DART AEROSPACE LTD	Work Order:	83491
Description: 206 Saddle, Inboard, Left side	Part Number:	D2662-2
Inspection Dwg: D2662 **Rev:** E **DSK:** **Rev:**		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**5**
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.118	.119	.121	.121	.119
G	0.210	0.230		.219	.219	.220	.220	.219
H	0.615	0.685		.680	.680	.680	.680	.680
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.323	1.323	1.325	1.324	1.324
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.132	1.133	1.137	1.136	1.134
N	0.100	0.180		.140	.140	.140	.140	.140
O	0.100	0.140		.116	.116	.113	.114	.115
P	0.240	0.260		.251	.250	.250	.249	.250
Q	0.677	0.697		.687	.687	.687	.687	.687
R	0.540	0.560		.550	.550	.550	.551	.550
S	0.912	0.932		.922	.922	.922	.922	.922
T	0.787	0.807		.797	.797	.797	.797	.797
U	5.990	6.010		6.001	6.001	6.001	6.001	6.001
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.499	.501	.501	.501	.502
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.123	.123	.124	.123	.125
AE	0.235	0.240		0.237	0.236	0237	0.236	0.236
AF	0.510	0.515		0.510	0.510	0.510	0.510	0.510
AG	0.100	0.120		0.116	0.115	0.117	0.116	0.116
AH	1.565	1.585		1.572	1.573	1.577	1.576	1.574
			Accept/Reject					

Measured by:	JL	**Date:**	12-05-14
Audited by:	D.A	**Date:**	12/05/16
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	